

18/05

Date: Thursday, 01/05/2008 2:14:50 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HEAD REST ASSEMBLY CENTER
Job Number	: 38956		
Estimate Number	: 10861		
P.O. Number	:	Part Number	: D412724041
This Issue	: 01/05/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: N/A
First Issue	: 01/05/2008	Project Number	: N/A
Previous Run	: 38415A	Drawing Revision	: N/A
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 16/05/2008
		Qty:	4 Um: Each
Checked & Approved By	: <u>JLD 08-5-01</u>		
Comment	: Est Rev:A 04.09.08 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------

**Comment:** DOCUMENT CONTROL

If D412-724-041 is a W/O on it's own,
 Photocopy bluefile and create labels per PPP D412-724-041 CHG001

808/05/23 08.5.06 JLD

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D3303041	Head Rest
-----	----------	-----------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description	Batch
1 D3303-041	Head Rest	<u>B38967</u>

Pick 8/5/23 (4)

4.0	D3304041	Tube Assembly
-----	----------	---------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description	Batch
1 D3304-041	Tube Assembly	<u>35438</u>

JS 8/05/20 (24)

5.0	AN52510R6	Screw
-----	-----------	-------

**Comment:** Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description	Batch
		<u>M15943</u>

JS 8/05/20 (24)

Date: Thursday, 01/05/2008 2:10:40 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAD REST ASSEMBLY CENTER

Job Number: 38956

Part Number: D412724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 AN525-10R6 Screw

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/05/23 (x4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(4x)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-724-041

Location:

PPP Rev:

A

8/5/23

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

3.0 INSTALLATION PROCEDURE

To install a Dart Head Rest Assembly:

- 3.1 If installed, remove the existing Head Rest Assembly by pulling the quick release pin that attaches it to the seat. Make note of the installation position (if applicable).
- 3.2 Inspect the seat for damage in the vicinity of the Head Rest Assembly. Consult the Aircraft Maintenance Manual for disposition if damage is observed.
- 3.3 If only replacing the Head Rest with the equivalent Dart D3303-041 Head Rest, separate the existing Head Rest from the existing Tube Assembly by undoing 4 screws. Re-assemble D3303-041 Head Rest with existing Tube Assembly by installing 4 screws and tightening to 15-25 in lb.
- 3.4 If only replacing the Tube Assembly with a Dart D3304-041/-043/-044 Tube Assembly, separate the existing Head Rest from the existing Tube Assembly by undoing 4 screws. Re-assemble existing Head Rest with Dart D3304-041/-043/-044 Tube Assembly by installing 4 screws and tightening to 15-25 in lb.
- 3.5 Slide the new or modified Head Rest Assembly into the seat tube and lock in place at the same location that the old Head Rest Assembly was installed (if applicable) using the quick release pin. Ensure pin is properly engaged.

4.0 WEIGHT AND BALANCE

There is negligible weight change associated with the installation of the Dart Head Rests.

5.0 PARTS LIST

QTY -011	QTY -041	QTY -043	QTY -044	Part Number	Description
X				D412-724-011	Dart Replacement Head Rest Kit, for 205/212/412
2	X			D412-724-041	Head Rest Assembly, Center
1		X		D412-724-043	Head Rest Assembly, LH
1			X	D412-724-044	Head Rest Assembly, RH
	1	1	1	D3303-041	Head Rest
	1			D3304-041	Tube Assembly
		1		D3304-043	Tube Assembly
			1	D3304-044	Tube Assembly
	4	4	4	AN525-10R6	Screw

W/o 38956

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries